

Work Order ID 70855

Thursday, June 16, 2011 2:21:15 PM



Page 1

Item ID: D3463-1

Accept



Setup Start



Revision ID:

Item Name: Arm

Stop



Start Date: 6/16/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:



Date: 11/08/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3463	Rev B								

100



BAND SAW

0.00

11/08/03

6

Bandsaw

Jeaspa Bandsaw

Memo

Cut blank 25.00 " long

0.00

105



Lathe Conv

Conventional Lathe

Memo

Ream tube at both ends aprox 2" deep at .750" Dia

0.00

11/08/03

6

110



Small Fab

Small Fab

Small Fab

Memo

1-Bend as per dwg D3463 2-Trim to lenght per dwg D3463 3- Deburr

0.00

11/08/05 6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

8/16/08

6

130



Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

0.00

8/16/08

6

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

8/16/08

6

W/O:		WORK ORDER CHANGES					
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Work Order ID 70855

Page 3

Thursday, June 16, 2011 2:21:15 PM

Item ID: D3463-1

Accept



Setup Start



Revision ID:

Item Name: Arm

Stop



Start Date: 6/16/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

150



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00 8 u/wo/08

(Y6)

160



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CMF 11-08-08

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NOTE: Date & initial all entries

Picklist Print

Thursday, June 16, 2011 2:21:22 PM

Page 1

Work Order ID: 70855



Parent Item: D3463-1



Parent Item Name: Arm

Start Date: 6/16/2011

Required Date: 6/23/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC
ADDED MANUAL LATHE STEP 10-06-02 JLM VER:DD

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M316TR1.00W.120		Purchased		No		100	f	25.5000	2.083	13.15579			

316 RD tubing 1.00 x .120w



Location	Loc Qty	Loc Code
MAT037	25.5	
111096	5.5	
117890	20	

118390

13.2 70 4/08/03

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NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD	Work Order:	70853
Description: Arm	Part Number:	D3463-1
Inspection Dwg: D3463	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>SA</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>11/08/08</u>	Date: <u>11/08/08</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue	KJ/JLM	
B	07.09.06	Dimensions added	KJ/JLM	E

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

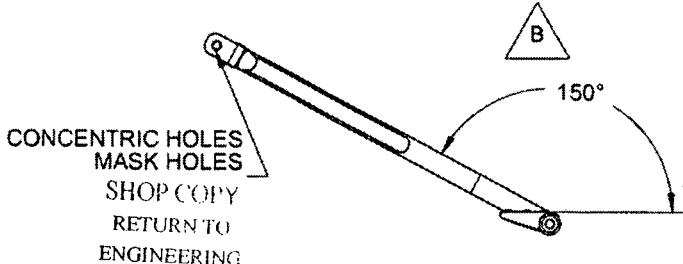
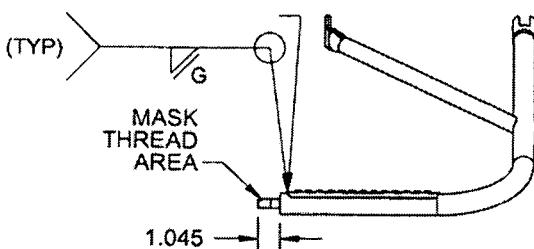
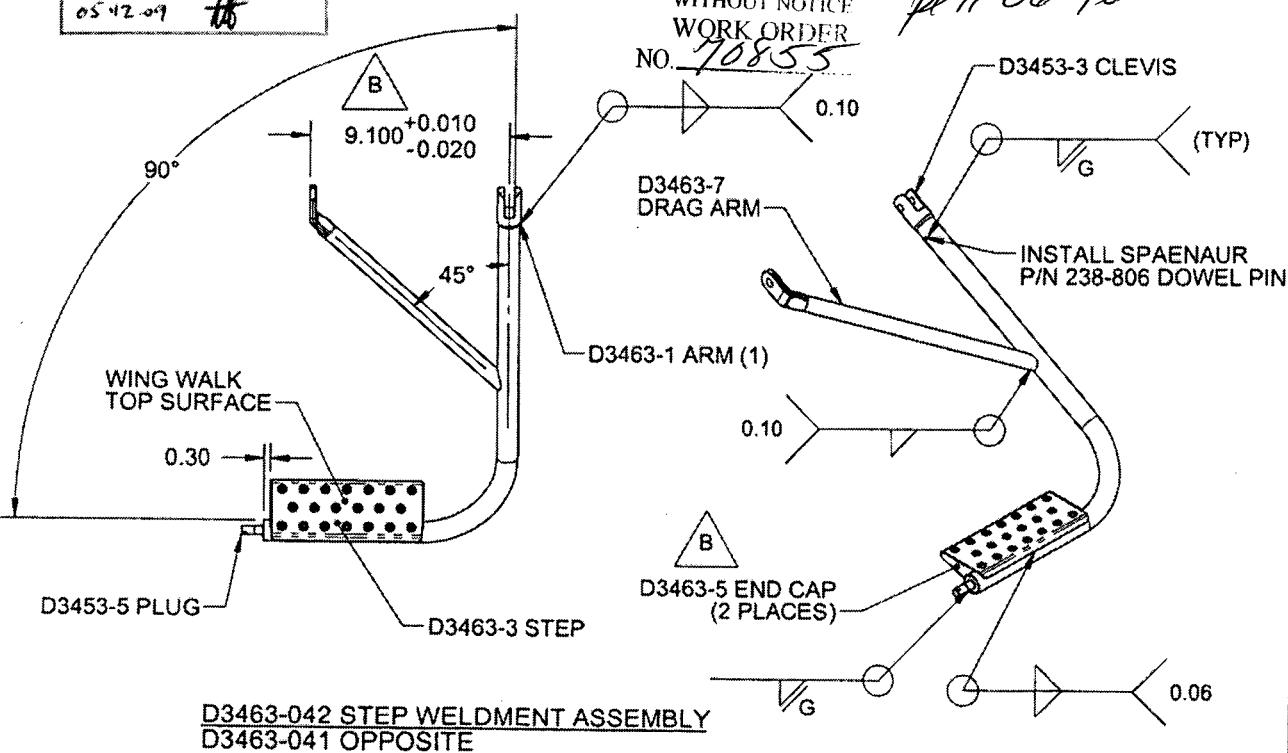
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>ff</i>	APPROVED <i>ff</i>	DRAWING NO. D3463
		REV. B SHEET 1 OF 4
DATE 05.12.05		TITLE STEP WELDMENT
		SCALE 1:8
A 05.09.20	NEW ISSUE	
B 05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

INSTALL P/N 238-806
DOWEL PINRELEASED
05-12-05 *ff***NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

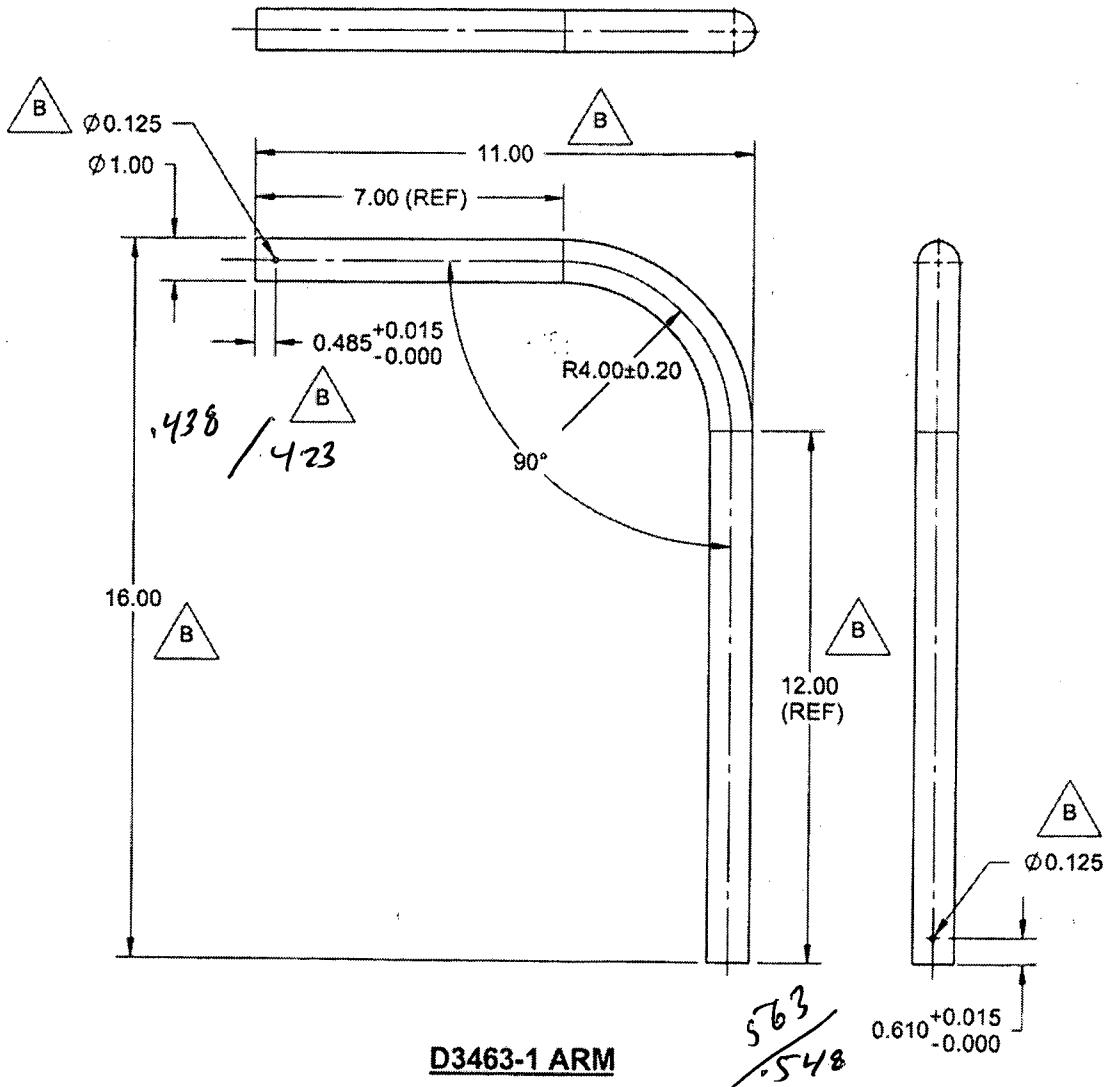
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.05 *[Signature]**W/10 10835***NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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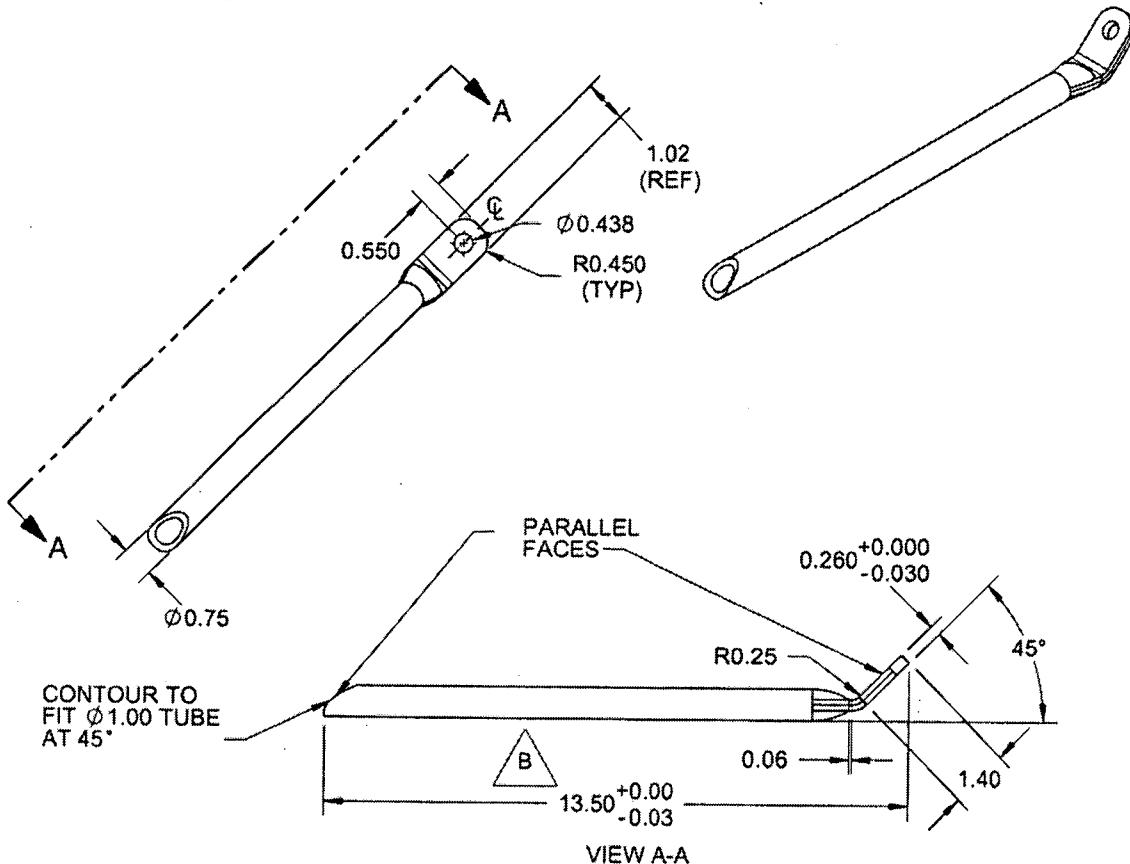
DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.05 *#*

W/ 70855

**D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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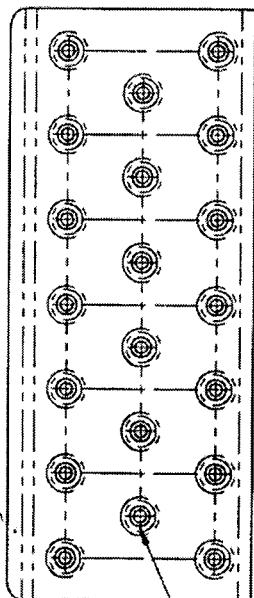
WB 70855

DART

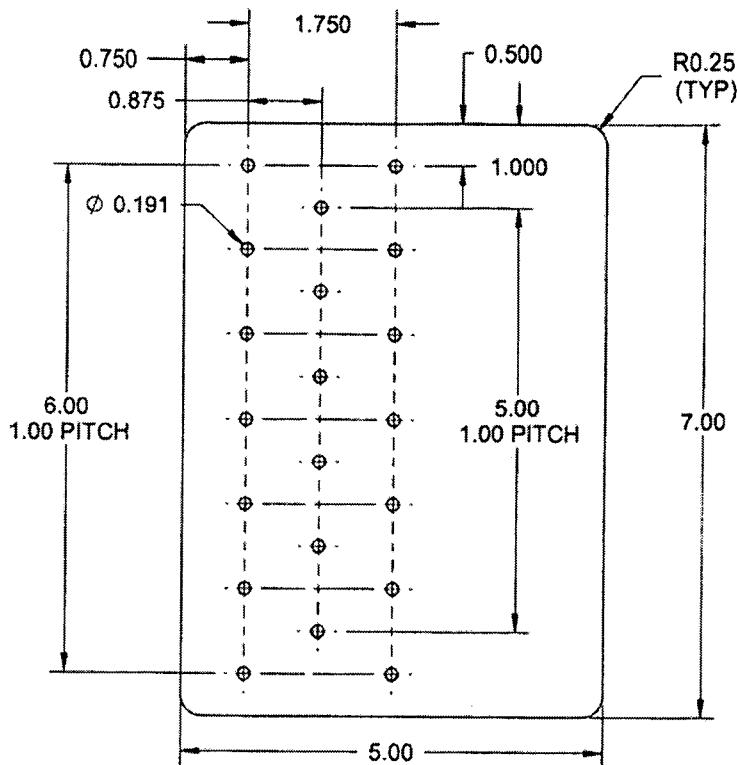
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT	SCALE 1:2	

RELEASED

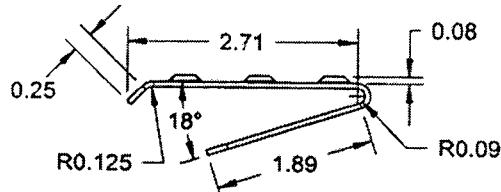
05.12.05 *[initials]*



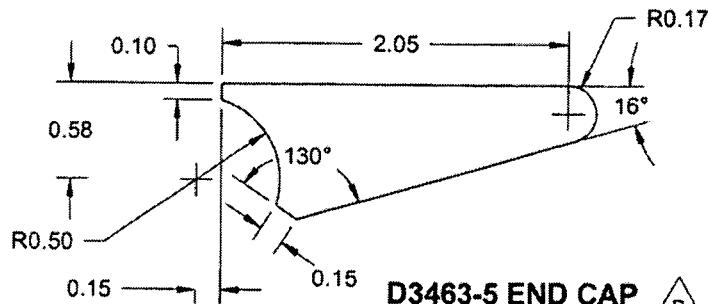
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP
SCALE 1:1



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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